



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

C45-3-6

Job Sheet 172244



Part No: C45-3-6

Job Qty: 1 ea

Part Name: Latch



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/14/18

Job Tracking No:

Due Date: 2/16/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: C45-3-6 rev.10 IPP REV:A 18.02.06 NEW ISSUE DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	2/15/18	2/15/18	0.00	0.00	Start Up Machining-4		
100	Bandsaw	1 pcs	2/15/18	2/15/18	0.00	0.05	Bandsaw1		
120	CNC Vertical Machining	1 pcs	2/16/18	2/16/18	0.50	0.50	MORI NV5000-1		
130	QC	1 pcs	2/16/18	2/16/18	0.00	0.00	QC2 Machining-5		
140	QC	1 pcs	2/16/18	2/16/18	0.00	0.00	QC8 Machining-5		
150	Packaging	1 pcs	2/16/18	2/16/18	0.00	0.00	Packaging3-2		
160	QC21-FG	1 Ea	2/16/18	2/16/18	0.00	0.00	QC21		

Part Op 100 - CUT BLANK AT 1.825"

Descriptions: 120 - 1-Machine as per folio FB814 FOLIO REV: _____ DWG REV: _____ 2-Deburr

130 - 1-Engrave Batch number as required Using Marktronic engraver as per DWG.

150 - Identify and Stock

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-B1.000X02.000	17-4 SS Bar 1.00 x 2.00	.1667 ft (.16666 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M17-4-B1.000X02.000	0	0	0

S030457-25042357

Part Specifications

Specifications could not be found.

Plex 2/14/18 1:03 PM Dart.lajeunesse.marie

QA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																																											
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval																																																																																									
Description Work Order Deviation		Disposition																																																																																											
DART Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 813 832-5200 Email: sales@dartaero.com www.dartaerospace.com				Completed By																																																																																									
				Lead hand / Supervisor Approval Verification																																																																																									
				QC / QA Coordinator Approval																																																																																									
Root Cause <table style="width:100%; border-collapse: collapse;"> <tr><td>Environment</td><td>☐</td><td>No R</td><td>☐</td></tr> <tr><td>Design</td><td>☐</td><td>Oper.</td><td>☐</td></tr> <tr><td>Doc/Data</td><td>☐</td><td>Offse</td><td>☐</td></tr> <tr><td>Equip/Tooling</td><td>☐</td><td>Suppl</td><td>☐</td></tr> <tr><td>Handling/Pre</td><td>☐</td><td>Traini</td><td>☐</td></tr> <tr><td>Material</td><td>☐</td><td>Use fc</td><td>☐</td></tr> <tr><td>Internal Transport</td><td>☐</td><td>Poor I</td><td>☐</td></tr> <tr><td>Tribal Knowledge</td><td>☐</td><td>Rushir</td><td>☐</td></tr> <tr><td>LOA</td><td>☐</td><td>Produ</td><td>☐</td></tr> <tr><td>Substation</td><td>☐</td><td>Proces</td><td>☐</td></tr> <tr><td>Past Expiry Date</td><td>☐</td><td>Manufacturing Process</td><td>☐</td></tr> <tr><td>Misidentified</td><td>☐</td><td>Past Due</td><td>☐</td></tr> </table>		Environment	☐	No R	☐	Design	☐	Oper.	☐	Doc/Data	☐	Offse	☐	Equip/Tooling	☐	Suppl	☐	Handling/Pre	☐	Traini	☐	Material	☐	Use fc	☐	Internal Transport	☐	Poor I	☐	Tribal Knowledge	☐	Rushir	☐	LOA	☐	Produ	☐	Substation	☐	Proces	☐	Past Expiry Date	☐	Manufacturing Process	☐	Misidentified	☐	Past Due	☐	Container No: S042360 Part: C45-3-6 Serial No/Batch: S042360 Revision: C45-3-6 Inspector: Date: 02/14/18 13:13 PM		<table style="width:100%; border-collapse: collapse;"> <tr><td>Loss/Surge</td><td>☐</td><td>Positioned Wrong</td><td>☐</td></tr> <tr><td>rogram</td><td>☐</td><td>Outside Dimensions</td><td>☐</td></tr> <tr><td></td><td>☐</td><td>Over/Under tolerance</td><td>☐</td></tr> <tr><td></td><td>☐</td><td>Part Incorrect</td><td>☐</td></tr> <tr><td>Stock Pulled</td><td>☐</td><td>Part Lost/Missing</td><td>☐</td></tr> <tr><td>sequence</td><td>☐</td><td>Part Moved</td><td>☐</td></tr> <tr><td></td><td>☐</td><td>Drawing</td><td>☐</td></tr> <tr><td>led</td><td>☐</td><td>Finish</td><td>☐</td></tr> <tr><td></td><td>☐</td><td>Misread</td><td>☐</td></tr> <tr><td></td><td>☐</td><td>Turning Sequence</td><td>☐</td></tr> </table>		Loss/Surge	☐	Positioned Wrong	☐	rogram	☐	Outside Dimensions	☐		☐	Over/Under tolerance	☐		☐	Part Incorrect	☐	Stock Pulled	☐	Part Lost/Missing	☐	sequence	☐	Part Moved	☐		☐	Drawing	☐	led	☐	Finish	☐		☐	Misread	☐		☐	Turning Sequence	☐
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OTHER : _____		Drill Holes ☐ Misaligned/off center ☐																																																																																											

DART AEROSPACE LTD	Work Order:	172897 17650
Description: LATCH	Part Number:	C45-3-6
Inspection Dwg: C453-6 Rev: 11		Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.178	$\pm .010$	.1780	-		Vernier	
.715	$\pm .005$	.712	-		"	
.375	$\pm .005$	.374	-		"	
.170	$\pm .005$	.166	-		"	
.490	$\pm .005$	.480	-		"	
.35	$\pm .001$	.353	-		"	
.30	$\pm .010$	.300	-		"	
.63°	$\pm \frac{1}{2}^{\circ}$	.63°	-		C-Square	
.766	$\pm .005$	.766	-		Vernier	
.105	$\pm .000$	.1052	-		"	
.26	$\pm .010$	.260	-		"	
.115	$\pm .005$	.115	/		"	
.44°	$\pm \frac{1}{2}^{\circ}$	.44°	-		C-Square	
.14°	$\pm \frac{1}{2}^{\circ}$	.14°	-		"	
1.33	$\pm .010$	1.329	-		Vernier	
.920	$\pm .005$	.918	-		"	
.44	$\pm .010$	.442	-		"	
.20°	$\pm \frac{1}{2}^{\circ}$	.20°	-		C-Square	
1.50	$\pm .010$	1.500	-		Vernier	
.486	$\pm .005$	.486	-		"	
.468	$\pm .005$	.4678	-		"	
.188	$\pm .005$	.187	-		"	
.146	$\pm .005$	.139	-		"	
.124	$\pm .005$	.124	-		"	
Ø.191	$\pm .005$	Ø.196	-		"	
Ø.376	$\pm .005$	Ø.377	-		"	
Ø.625	$\pm .005$	Ø.625	-		"	
.045	$\pm .005$	.050	-		"	
Ø.526	$\pm .001$	Ø.526	-		"	

Measured by:	<i>[Signature]</i>	Checked by:	<i>[Signature]</i> 20 9-89	QC Inspector:	
Date:	18/02/14	Date:	18-02-14	Date:	

Engineering Approval: (If necessary)		Date:
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Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	